








Forming Tap M12 Z4

A10-300

The manufacturing cycle includes the loading and dressing cycle for conventional wheels for flute and thread grinding. After further research in wheel technology the cycle time could be reduced. The thread is dressed with a formroll.



1. Cycletime for Production

Tool specifications M12, flutelength 29 Material HSSE				
Operations				
	Loading	Thread rough	Thread fine	dress thread
Feed [mm/Min]		11000	11000	100
Power [kW]		4	4	1
Cutting feed [m/s]		65	65	24
Used wheels				
Grinding time [s]	20	26	20	30
Total cycle time	1 Min 36			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

37 Ø400 1A1 A250

38 Ø90 DXF D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : TAP NGM, dressing unit
Control: Fanuc 31i B5
Coolant: Synthetic Oil, pressure 9 bar
Software: Quinto 5.4.6

responsible engineer:

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